

Date: Thursday, 07/05/2009 3:30:45 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : HANDLE
<b>Job Number</b> : 47801	
<b>Estimate Number</b> : 11212	
<b>P.O. Number</b> :	<b>Part Number</b> : D33321
<b>This Issue</b> : 07/05/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3332 REV A1
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : A1
<b>Previous Run</b> : 47613	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 15/05/2009 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>mk 09-05-11</u>	
<b>Comment</b> : Est: B 05.06.20 Holes no longer made by machine KJ/JLM Est Rev:C Now on Doosan 08-07-09 JLM Verified By:EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M1018R2000	1018-1025 round bar 2.00
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**Comment:** Qty.: 0.0218 f(s)/Unit Total : 0.2184 f(s)  
 1018-1025 Steel Bar  
 Material: AISI 1018-1025 Ø2.00" Round Bar  
 (M1018-R2.000)  
 Identify for D3332-1  
 Batch: 116639

mk 09/05/09

(10)

2.0	DOOSAN LATHE	DOOSAN LATHE
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**Comment:** DOOSAN LATHE  
 Turn as per Folio FA494 and Dwg D3332

mk 09/05/09

(10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

mk 09/05/09

(10)

4.0	QC8	SECOND CHECK
-----	-----	--------------



**Comment:** SECOND CHECK

SA 09/05/10

(10)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



**Comment:** PACKAGING RESOURCE #1  
 Identify and Stock  
 Location: Carl L.

SS 09/05/11

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 07/05/2009 3:30:45 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE

Job Number: 47801

Part Number: D33321

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/12 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF  
09-05-11

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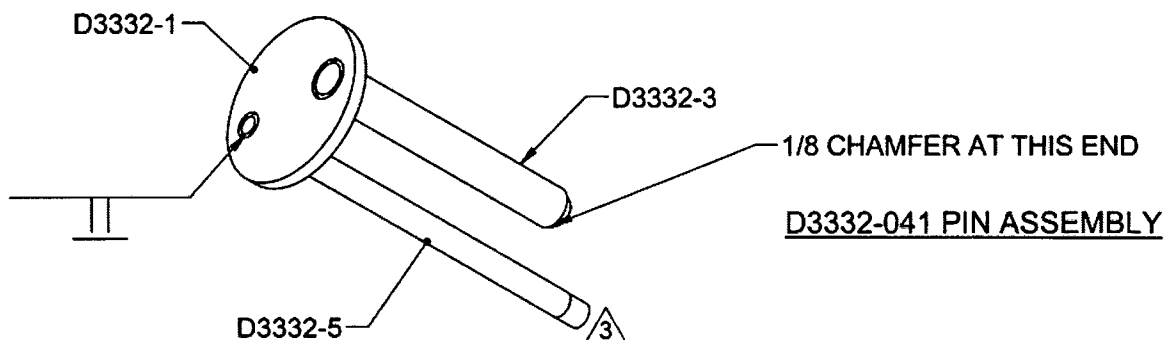
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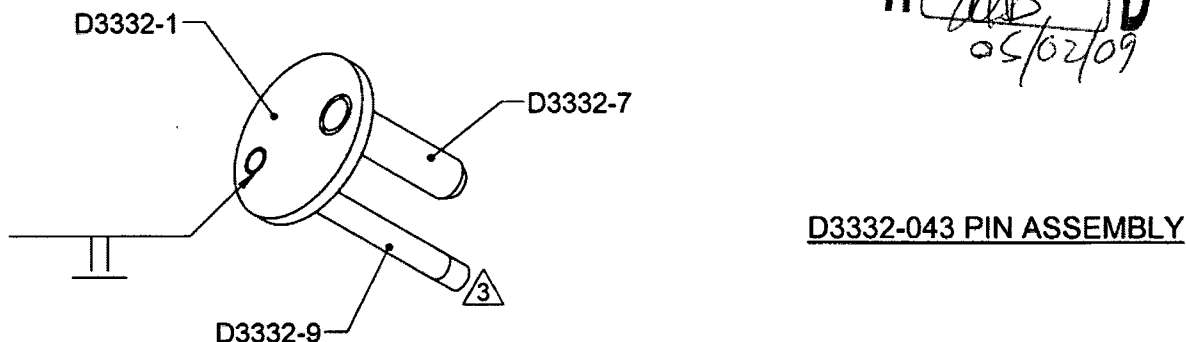
**NOTE:** Date & initial all entries

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3332</b>	REV. A SHEET 1 OF 4
DATE <b>04.12.14</b>		TITLE <b>PIN ASSEMBLY</b>	SCALE 1:2
A	04.12.14	NEW ISSUE	
A1	<i>[Signature]</i> 05.07.04	0.080 WAS 0.050; ADD TOLERANCE $\pm 0.000$ TO 0.005	



**RELEASED**  
*[Signature]*  
05/02/09

**NOTES:**

- 1) POSITION PARTS USING D3332-041T1
- 2) WELD PER DART QSI 004
- 3) MASK THREADS PRIOR PAINTING
- 4) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER QSI 005 4.3 SUBJECT TO AMENDMENT (COVER THREAD ONLY FOR D3332-5/-9 PRIOR PAINTING)
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.10

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NO. *47801*

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

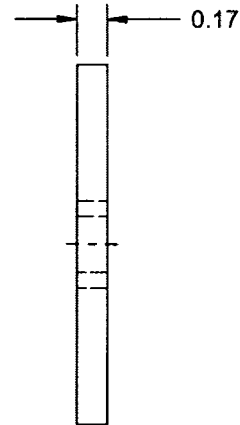
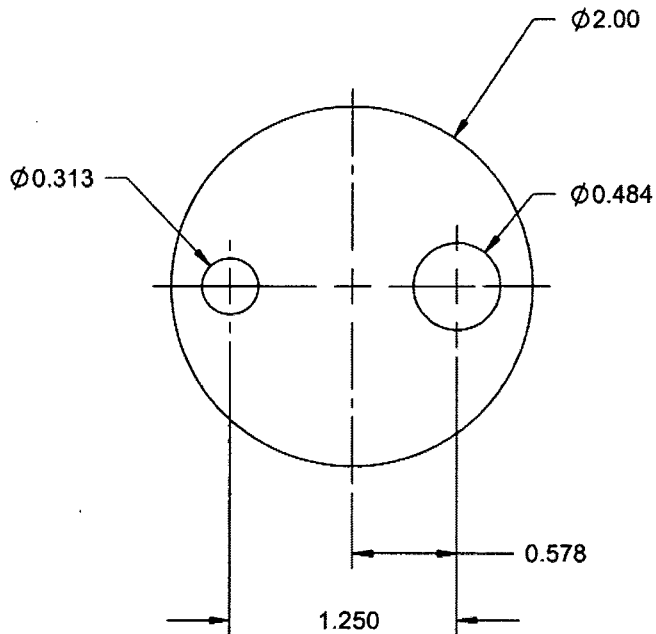
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**NOTE:** Date & initial all entries



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DATE <b>04.12.14</b>		TITLE <b>PIN ASSEMBLY</b>	SCALE 1:1



**RELEASED**  
*[Signature]*  
05/04/09

**D3332-1 HANDLE****NOTES:**

- 1) MATERIAL: 1018-25 ROUND BAR STEEL PER MIL-S-7097  
(REF. DART SPEC. M1018-R2.000)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

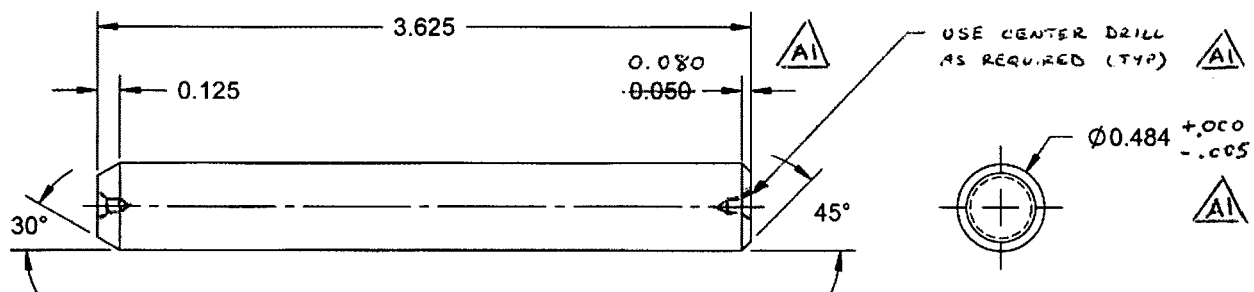
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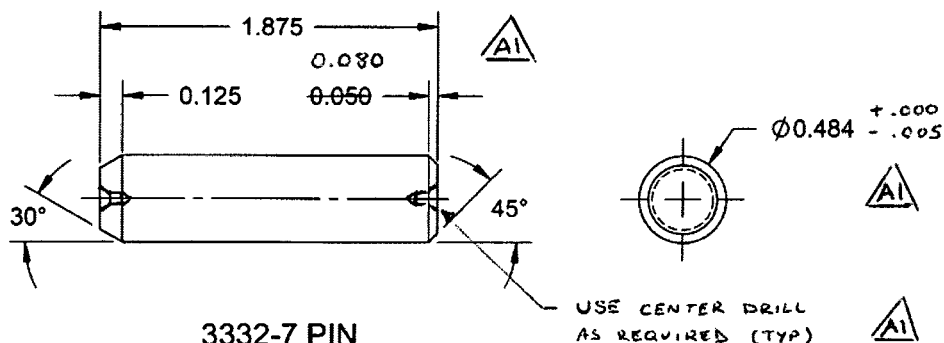


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3332</b>	REV. A SHEET 3 OF 4
DATE <b>04.12.14</b>		TITLE <b>PIN ASSEMBLY</b>	SCALE 1:1



**3332-3 PIN**

**RELEASED**  
*[Signature]*  
05/02/09



**3332-7 PIN**

**NOTES:**

- 1) MATERIAL: 1018-1025 ROUND BAR STEEL PER MIL-S-7097 (REF. DART SPEC. M1018R0.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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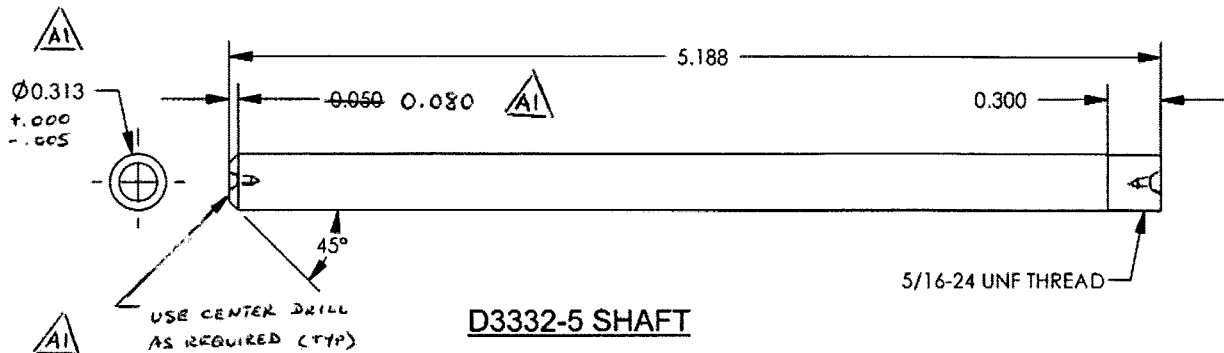
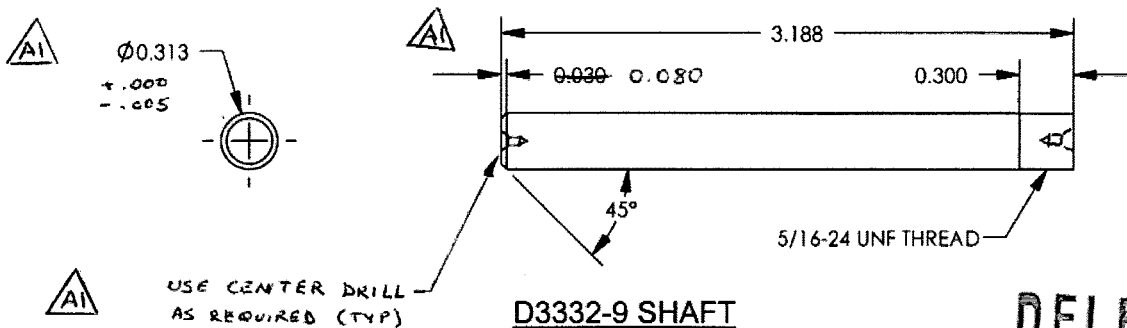
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**D3332-5 SHAFT****D3332-9 SHAFT**

**RELEASED**  
*[Signature]*  
05/02/09

**NOTES:**

- 1) MATERIAL: 1018-1025 ROUND BAR STEEL PER MIL-S-7097 (REF. DART SPEC. M1018-R0.313)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
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